



Dart Aerospace Ltd.
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Canada

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D3171-1
Job Sheet 186230



Part No: D3171-1

Job Qty: 20 ea

DAS
21
9-89

Part Name: Angle Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/13/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B SHEET 1 IPP A 02.11.04 New Issue KJ IPP Rev:B 08-03-27 now on water jet DD verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs		11/30/18	0.00	0.95	Waterjet - Flow		Dec 18/11/14
110	QC	20 pcs		11/30/18	0.00	0.00	QC2 Waterjet-1		Dec 18/11/14
120	QC	20 pcs		11/30/18	0.00	0.00	QC8-2		38
130	Brake NC	20 pcs		11/30/18	0.03	0.50	Brake NC 1		DAS 38
150	QC	20 pcs		11/30/18	0.00	0.00	QC5		38
160	Packaging	20 pcs		11/30/18	0.00	0.00	Packaging3		38
170	QC21-SA	20 Ea		11/30/18	0.00	0.00	QC21		NOV 15 2018

Part Op 100 - 1-Cut as per Dwg D3171
Descriptions: 130 - Bend as per Dwg D3171

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.4120 sf (.0206 ea)	100-Waterjet - Flow - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	0	197	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Angle	0.500inches + 0.006 - 0.001	0.506 0.499	Diameter	
2	Angle	0.257inches + 0.006 - 0.001	0.263 0.256	Diameter	
3	Angle	2.517inches ± 0.010	2.527 2.507		
4	Angle	1.180inches ± 0.010	1.190 1.170		
5	Angle	1.527inches ± 0.010	1.537 1.517		
6	Angle	0.400inches ± 0.010	0.410 0.390		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																					
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Container No: S127658



Part: D3171-1

Job No: 186230

Serial No/Batch: S127658

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.

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CANADA

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Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/14/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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